	<b>er ID 121476</b> 26, 2014 3:00:47 PM		*121	476*						Page 1
Item ID: Revision ID: Item Name:	D3465-1 Washer	01-	Accept	*N900	040	100	<b>)*</b> s	Setup St	1.	JS1* JS2*
Start Date: Required Date: Reference:	6/26/14 Start Qty: 5.00 Req'd Qty: 6.00	390° *6* *6*		Cust Item :	ID:					u. 17
Approvals:	Process Plan: MLJ	Date: 14-06-	Z7 Tooling:	D	ate:	_	R	•	art <b>*</b>	JR1*
	QC:			D	ate:			St	op <b>*</b> [	JR2*
Sequence ID/ Work Center II	Operation Description	*	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Numbe	Insp.
Draw Nbr	Revision Nbr								<del></del>	
D3465	Rev B									
*100  *100  Hardinge  Hardinge CNC Lath		AS PER FOLIO FA602 &	0.00 0.00 DWG D3465 ,FOLIO _ 2-DEBURR AS REQUIREI	D			_32	Ø		11/07/1·
*110 * QC Quality Control	QC2- Inspect parts of	f machine FAI/FAIB	0.00				32			[15] - [14]07[1
120 <b>*1 ? *1 ? OC</b> Quality Control	QC8- Inspect parts - s  Memo	second check	0.00				_32	Ø		DAS 40 9-89 14/07/18

DQA:							CONFORMANCE / UPDATE							
QA Closed:		Date:			WORK ORDER NON-	-CC	JNFUI	RIVIAINCE / UI		Wo	ork Order up	date only	AEROSPACE	
·					DISPOSITION				AGAINST I	DEF	PARTMENT	PROCESS		
Work Orde	r:					. 1			-				7	
					Rework		Skid-tube Crosstube Machining Small Fab				Dro	Water Jet d. Eng. Coor.	Engineering Quality	
Part N	o				Scrap Use-as-is			Machining	Finishing	$\dashv$		e/Packaging	Other	
NCR No.				Suspected Unapproved		Thermoforming Finishin  Large Fab Composit				Nec/3tol	Supplier			
Root		1		Desc	ription of work order update		nitial	Act	ion		Sign &			
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption		Date	Verification	QC Inspector	
Design										ĺ				
Doc/Data														
quip/Tooling		}												
Handling/Pre														
Material														
Operator		ļ												
Offset/Setup														
Process										ŀ				
Supplier		ł				İ								
Training														
Transport				,										
Unapproved			<u> </u>	<u> </u>		L		ļ						
						FA	ULT CA	TEGORY			***			
Landin	g Gear			_	General		1		г				7	
Ĺ	Bending			<u> </u>	Bend		4	rogram	ļ	—	Outside Dim	<del> </del>	Pressure/Forced	
	Centre N	ot Conce	ntric	<u> </u>	BOM/Route		Grain		,	-	Over/Under	<del></del>	Set-up	
<u> </u>	Cracks			<u> </u>	Broken/Damage/Defect		Hardwa			-	Part Incorred	<u> </u>	Temperature/Cure	
1	Crimp/Kii	nk/Ripple	e/Wave	_	Burrs	<u></u>	┪ '	ion Incomplete/Ur	· .	-	Part Lost/Mi	ssing	Weld	
	Cuffs			ļ	Contamination		-	ions Incomplete/U	Jnclear	-	Part Moved		Wrong Stock Pulled	
ļ	Crushing		L	Countersink		-1	ned/off center		_	Positioned V		7		
ļ	Heat Trea			<u> </u>	Cut Too Short	<u></u>	Mislabe		Į		Power Loss/	Surge	Other	
	Inspection Strip in Tube		Drawing	$ldsymbol{le}}}}}}$	Misrea									
Į	Marks/Chatter		Drill Holes		Off-set									
	Turning S	equence			Finish		4	Calibration						
	Wave/Twist in Tube				Fit/Function	1	Out of	Sequence						

150

\*150\*

Packaging

Packaging

Identify as per dwg & Stock Location:

Memo

0.00

32x\_

14-7-2128

DQA:	Date:													
						WORK ORDER NON-	-CC	ONFO	RMANCE / UP				_	AEROSPACE
QA Closed:			Date:							W	ork Order up	date only		
Work Orde	r.					DISPOSITION				AGAINST DE	EPARTMENT/PROCESS			
WOIR Olde	٠					Rework			Skid-tube Crosstube		1	Water Jet	$\neg$	Engineering
Part N	ο.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	┪	Quality
,	-	40				Use-as-is			noforming	Finishing	-{	e/Packaging	٦	Other
NCR N	o.					Suspected Unapproved			Large Fab	Composite		Supplier		
			***		-							· .		· • • • • • • • • • • • • • • • • • • •
Root					Desc	ription of work order update	ı	nitial	Acti		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	4	QC Inspector
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Doc/Data														
Equip/Tooling														
Handling/Pre	_													
Material	_								٤					
Operator	_		:											
Offset/Setup	_													
Process	_													
Supplier	_												1	
Training	$\dashv$				İ								1	
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							FAI	ULI CA	regory					
Landir [	_					General		الدمان الا	rogram		Outside Dim	onsions [	一,	Pressure/Forced
}		Bending	at Camaa			Bend BOM/Route	_	Grain	Togram	<del>                                     </del>	Over/Under	<b>├-</b>		Set-up
}	-	Centre No	or concer	ntric	-	Broken/Damage/Defect	-	Hardwa	aro	<u></u>	Part Incorred	F-	_	Temperature/Cure
}	$\dashv$	Crime / Kin	nk/Binnlo	Mayo	$\vdash$	<b>-</b>	$\vdash$	-	ire ion Incomplete/Un	qualified —	Part Lost/Mi		_	Weld
	-	Crimp/Kit	пк/кірріе	y wave		Burrs	_	4 ·	tions Incomplete/U	· –	Part Moved	331118		Wrong Stock Pulled
}		Crushing				Contamination Countersink		4	gned/off center	-	Positioned V	L Vrong		vviolig Stock i ulicu
}	-	Crushing Heat Trea			-	Cut Too Short		Mislabe	-		Power Loss/	_	$\neg$	Other
}		Inspectio		Tubo	-	Drawing	$\vdash$	Misrea		<u> </u>	J. 044Ci 1033/			
	$\overline{}$			lune	 	Drill Holes	$\vdash$	Off-set			_			
	Marks/Chatter				Finish		4	Calibration						
	Turning Sequence Wave/Twist in Tube				Fit/Function	Out of Sequence							<del>,, , ,, ,, ,, ,, ,, ,, ,, ,, ,, ,, ,, ,</del>	

Work Ore Thursday, Jun			*121476*									Page 3
Item ID: Revision ID: Item Name:	D3465-1 Washer			Accept	*N900	040	100	)*	Setup	Start Stop		S1* S2*
Start Date: Required Dat Reference:	6/26/14 e: 6/26/14	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item l Customer:	D:						
Approvals:	Process QC:	Plan:	Date:	Tooling: SPC (Y/N):		ate:			Run	Start Stop	*N	R1* R2*
Sequence ID/ Work Center	ID	Operation Description QC21- Final Inspection -	Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number /	Insp. Stamp
*160* QC Quality Control		Memo		0.00						4/-	1/20	2 SS- NF 14-7-21

DQA:	Date:				. WORK ORDER NON-CONFORMANCE / UPDATE										
QA Closed:			Date:			WORK ORDER NON-	·CC	JNFOI	RMANCE / U		Wo	ork Order up	odate only	AEROSPACE	
						DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Work Orde	er: -					_				_					
						Rework		Skid-tube Crosstube  Machining Small Fab			Dro	Water Jet d. Eng. Coor.	Engineering Quality		
Part N	10.					Scrap Use-as-is			Machining noforming	Finishing			re/Packaging	Other	
NCR No.				Suspected Unapproved		IIICII	Large Fab	Composite		1100,0101	Supplier				
Nen	•••					ouspeated onapproved					_				
Root					Desc	ription of work order update	ı	nitial	Act	ion		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription		Date	Verification	QC Inspector	
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Handling/Pre											- 1				
Material															
Operator	Щ								-						
Offset/Setup	Щ														
Process	Ш														
Supplier															
Training	Н														
Transport	Н														
Unapproved				<u> </u>	<u> </u>			LILT CA	FECORY					<u> </u>	
1 1				<del></del>		General	FAI	ULI CA	TEGORY						
Landi		Bending				Bend		احمانم/د	Program	1	$\neg$	Outside Dim	ensions [	Pressure/Forced	
	$\vdash$	_	ot Concer	ntric	-	BOM/Route	_	Grain	rogram	ŀ	-	Over/Under	<u> </u>	Set-up	
		Cracks	or concer	itiic		Broken/Damage/Defect	⊢	Hardwa	are		-	Part Incorre	<u> </u>	Temperature/Cure	
			nk/Ripple	/Wave		Burrs	-	-	ion Incomplete/Ui	ngualified	-	Part Lost/Mi	<b> </b>	Weld	
		Cuffs	ing rappie,	, wave	-	Contamination		4	tions Incomplete/l	ì	-	Part Moved		Wrong Stock Pulled	
		Crushing				Countersink		4	gned/off center		-	Positioned V	ــــ Vrong		
	Heat Treat			Cut Too Short	Т	Mislab	-			Power Loss/	_	Other			
	Inspection Strip in Tube		Drawing	Г	Misrea		·		·	<b>L</b>					
:	Marks/Chatter		Drill Holes	Г	Off-set										
	Turning Sequence		Finish		4	Calibration		•							
	Wave/Twist in Tube				Fit/Function		Out of	Sequence							

**Picklist Print** 

Thursday, June 26, 2014 3:00:46 PM

Work Order ID: 121476

\*121476\*

Parent Item:

D3465-1

\*D3465-1\*

Parent Item Name: Washer

**Start Date:** 6/26/14

Required Date: 6/26/14

Start Qty: 6.00

Required Qty: 6.00

**Comments:** 

IPP REV. A 05.11.18

**NEW ISSUE** 

EC

Component Item ID/ Item Name

Replacement Mfg/ Item ID

**Purch** 

Bin Primary Item Location

Last Location Route Seq ID Unit of Measure Hand

Qty on

Qty per Kit Total

\*\*

Qty

1

Date **Issued** 

Status

M303R1.000

Purchased

No

34.6667

0.0218

Issued

Qty

100

f

Page 1

\*M303R1 000\*

303 Round Bar 1.00

Location

**MAT028** 

Loc Qty 34.6667

34.6667

Loc Code

M126618 -

m128496

- 0,632 hol

DQA:								"DART						
						WORK ORDER NON-	-CC	ONFO	RMANCE / UP					AEROSPACE
QA Closed:			Date:							W	ork Order up	date only		
Mark Orde						DISPOSITION				AGAINST DE	IST DEPARTMENT/PROCESS			
Work Orde	٠٠.					Rework			Skid-tube Crosstube			Water Jet		Engineering
Part N	lo.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.		Quality
				-		Use-as-is		Thern	noforming	Finishing	Rec/Stor	e/Packaging		Other
NCR N	NCR No.				Suspected Unapproved			Large Fab	Composite	]	Supplier			
Root					Desc	ription of work order update	ı	Initial	Acti	on	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	n	QC Inspector
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Unapproved				<u> </u>					<u> </u>	<del></del>				
							FA	ULT CA	TEGORY		<del></del>	<u> </u>		<u> </u>
Landi	ng (	1			_	General	_	1 <i>.</i> _	_	<b>,</b>	<b>1</b>		_	l_ <i>,_</i> .
		Bending			-	Bend	<u> </u>	-	Program	ļ	Outside Dim		<u> </u>	Pressure/Forced
		Centre No	ot Concer	ntric	<u> </u>	BOM/Route	<u> </u>	Grain			Over/Under			Set-up
		Cracks			<u> </u>	Broken/Damage/Defect		Hardwa			Part Incorre		<u> </u>	Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		<b>⊣</b> `	ion Incomplete/Un	· -	Part Lost/Mi	ssing	<u>.</u>	Weld
	L	Cuffs			<u> </u>	Contamination		4	tions Incomplete/U	nclear	Part Moved		L	Wrong Stock Pulled
		Crushing			<u> </u>	Countersink	L	-1	gned/off center	ļ	Positioned V	-	_	1
	Heat Treat		Cut Too Short	L	Mislabe		<u> </u>	Power Loss/	Surge	L	Other			
	Inspection Strip in Tube		Drawing		Misrea				<del> </del>		<u>45</u>			
	Marks/Chatter		Drill Holes	_	Off-set						₹). ****			
Turning Sequence			Finish		4	Calibration								
ĺ	Wave/Twist in Tube		Fit/Function	1	Out of	Sequence								

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

DART AEROSPACE LTD	Work Order:	121476
Description: Washer	Part Number:	D3465-1
Inspection Dwg: D3465 Rev: B		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments			
Ø0.453	+0.006/-0.001	0 454	1		11104	Sern			
Ø1.00	+0.010/-0.001	1000	1/		, , ,				
0.125	+/-0.010	0 130	/			, , ,			

Ø0.453	+0.006/-0.001	0,454	/	11/04	Sern
Ø1.00	+0.010/-0.001	1000		, , ,	r 13
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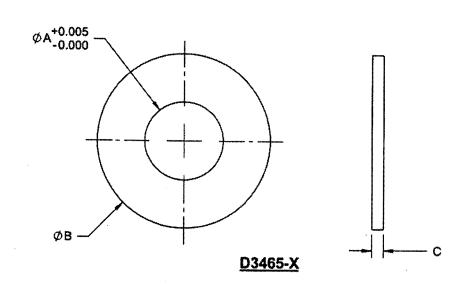
proval: N	N/A
Date: N	N/A
_	

Rev	Date	Change	Revised by	Approved
Α	07.09.06	New Issue	KJ/JLM o	E



	RF	DRAWN BY RF	DART AEROSP HAWKESBURY, ONTO	
CHECH	KED#	APPROVED	D3465	REV. B SHEET 1 OF 1
DATE	05.1	2.05	WASHER	SCALE 2:1
Α	0:	5.09.02	NEW ISSUE	
В	0:	5.12.05	0.125 WAS 0.065	

## RELEASED



### 1) SPECIFICATION: D3465-X WASHER

DASH No.

# WHERE 'X' IS THE SIZE PER THE FOLLOWING TABLE:

DASH	A	B	C
No.	(in)	(in)	(in)
-1	0.453	1.00	0.125

UNCONTROLLED COPY SUBJECT TO AMENDMENT RETURN TO

1) MATERIAL: AISI 303 SS ROUND BAR (REF. DART SPEC. M303R) \$
2) FINISH: NONE
3) IDENTIFY WITH P/N USING FINE POINT PERMANENT MARKER
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES
6) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010